



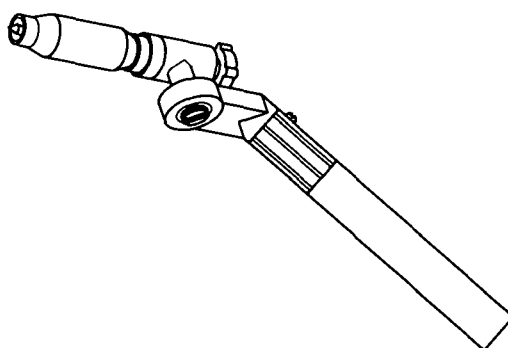
## MODEL

MTTF-1512

MTTF-1525

MTTF-1512V

MTTF-1525V

FILE COPY  
RETURN TO FOLDER

# OWNER'S MANUAL

**IMPORTANT:** Read and understand the entire contents of both this manual and the power source manual used with this unit, with special emphasis on the safety material throughout both manuals, before installing, operating, or maintaining this equipment. This unit and these instructions are for use only by persons trained and experienced in the safe operation of welding equipment. Do not allow untrained persons to install, operate, or maintain this unit. Contact your distributor if you do not fully understand these instructions.

**Miller Electric Mfg. Co.**A Miller Group Ltd. Company

P.O. Box 1079  
Appleton, WI 54912 USA  
Tel. 414-734-9821

# LIMITED WARRANTY

EFFECTIVE: FEBRUARY 16, 1988

This warranty supersedes all previous MILLER warranties and is exclusive with no other guarantees or warranties expressed or implied.

**LIMITED WARRANTY** - Subject to the terms and conditions hereof, Miller Electric Mfg. Co., Appleton, Wisconsin warrants to its Distributor/Dealer that all new and unused Equipment furnished by Miller is free from defect in workmanship and material as of the time and place of delivery by Miller. No warranty is made by Miller with respect to engines, trade accessories or other items manufactured by others. Such engines, trade accessories and other items are sold subject to the warranties of their respective manufacturers, if any. All engines are warranted by their manufacturer for one year from date of original purchase, except Tecumseh engines which have a two year warranty.

Except as specified below, Miller's warranty does not apply to components having normal useful life of less than one (1) year, such as spot welder tips, relay and contactor points, MILLERMATIC parts that come in contact with the welding wire including nozzles and nozzle insulators where failure does not result from defect in workmanship or material.

Miller shall be required to honor warranty claims on warranted Equipment in the event of failure resulting from a defect within the following periods from the date of delivery of Equipment to the original user:

1. Arc welders, power sources, robots, and components . . . 1 year
2. Load banks . . . . . 1 year
3. Original main power rectifiers . . . . . 3 years  
(labor - 1 year only)
4. All welding guns, feeder/guns and torches . . . . . 90 days
5. All other Millermatic Feeders . . . . . 1 year
6. Replacement or repair parts, exclusive of labor . . . 60 days
7. Batteries . . . . . 6 months

provided that Miller is notified in writing within thirty (30) days of the date of such failure.

As a matter of general policy only, Miller may honor claims submitted by the original user within the foregoing periods.

In the case of Miller's breach of warranty or any other duty with respect to the quality of any goods, the exclusive remedies therefore shall be, at Miller's option (1) repair or (2) replacement or, where authorized in writing by Miller in appropriate cases, (3) the reasonable cost of repair or replacement at an authorized Miller service station or (4) payment of or credit for the purchase price (less reasonable depreciation based upon actual use) upon return of the goods at Customer's risk and expense. MILLER's option of repair or replacement will be F.O.B., Factory, at Appleton, Wisconsin, or F.O.B., at a MILLER authorized service facility, therefore, no compensation for transportation costs of any kind will be allowed. Upon receipt of notice of apparent defect or failure, Miller shall instruct the claimant on the warranty claim procedures to be followed.

ANY EXPRESS WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTY OR REPRESENTATION AS TO PERFORMANCE, AND ANY REMEDY FOR BREACH OF CONTRACT WHICH, BUT FOR THIS PROVISION, MIGHT ARISE BY IMPLICATION, OPERATION OF LAW, CUSTOM OF TRADE OR COURSE OF DEALING, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR OF FITNESS FOR PARTICULAR PURPOSE, WITH RESPECT TO ANY AND ALL EQUIPMENT FURNISHED BY MILLER IS EXCLUDED AND DISCLAIMED BY MILLER.

EXCEPT AS EXPRESSLY PROVIDED BY MILLER IN WRITING, MILLER PRODUCTS ARE INTENDED FOR ULTIMATE PURCHASE BY COMMERCIAL/INDUSTRIAL USERS AND FOR OPERATION BY PERSONS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT AND NOT FOR CONSUMERS OR CONSUMER USE. MILLER'S WARRANTIES DO NOT EXTEND TO, AND NO RESELLER IS AUTHORIZED TO EXTEND MILLER'S WARRANTIES TO, ANY CONSUMER.

## SECTION 1 - SAFETY RULES

**WARNING:** UNSAFE PROCEDURES OR PRACTICES can cause serious personal injury or death.

- Read, understand, and follow ALL of these safety rules before installing, operating, or servicing this equipment.
- Be sure that all end users of this equipment, the operator and helpers, read and understand these safety rules.

### 1 - 1. PREVENT ELECTRIC SHOCK

Touching live electrical parts can cause severe burns to the body or fatal shock. Severity of electrical shock is determined by the path and amount of current through the body. Therefore:

- Do not touch live electrical parts.
- Do not work in wet or damp areas.
- Wear dry insulating gloves and body protection.
- Disconnect all power before installing or servicing this equipment.
- Turn off all equipment when not in use.
- Properly install and ground the welding power source according to its Owner's Manual and all applicable codes.
- Do not use worn or damaged cables or cables that are too small or poorly spliced.
- Do not wrap cables around your body.
- Do not touch electrode and any grounded object or circuit at the same time.
- Use only well-maintained equipment. Repair or replace damaged parts at once.

### 1 - 2. PROVIDE PROTECTION FROM FUMES AND GASES

Breathing welding fumes and gases can be hazardous to your health.

- Keep your head out of the fumes.
- Use adequate ventilation in the work area to keep fumes and gases from your breathing zone and the general work area.
- If ventilation is inadequate, use an approved breathing device.
- Read the Material Safety Data Sheets (MSDSs) and the manufacturer's instructions for any materials used.

### 1 - 3. PROTECT EYES AND SKIN FROM ARC RAYS; PROTECT EARS FROM NOISE

Arc rays from the welding process produce intense heat and strong ultraviolet rays that can burn eyes and skin. Noise from some processes can damage hearing.

- Wear a welding helmet fitted with a proper filter lens (see ANSI Z49.1 for detailed information).
- Use protective screens or barriers to protect others from flash and glare.
- Wear protective clothing and foot protection.
- Always wear safety glasses or safety goggles in a work area.

### 1 - 4. PREVENT FIRES AND BURNS

The hot workpiece, hot equipment, other hot metal, spatter, and arc sparks can cause fires and burns.

- Wear correct eye, face, and body protection in the work area.
- Allow work and equipment to cool before handling.
- Do not weld near combustible material.
- Watch for fire, and keep a fire extinguisher nearby.
- For additional information, refer to NFPA Standard 51B, "Fire Prevention in Use of Cutting and Welding Processes," available from the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

### 1 - 5. PROTECT COMPRESSED GAS CYLINDERS

Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, and arcs.
- Install and secure cylinders so that they cannot fall or tip over by fastening them to a mounting bracket, wall, or other stationary support.
- Keep cylinders away from any welding or other electrical circuits.
- Never allow a welding electrode to touch any cylinder.

## **1 - 6. PROVIDE PROTECTION FOR SPECIAL SITUATIONS**

- a. Do not weld or cut containers or materials which have held or been in contact with hazardous substances unless they are properly cleaned and inspected.
- b. Do not weld or cut painted or plated parts unless special ventilation is provided to remove highly toxic fumes or gases.
- c. Since welding can affect pacemakers, keep all pacemaker wearers out of the work area. Have them consult a doctor before coming near a welding operation.

## **1 - 7. PROVIDE PROPER EQUIPMENT MAINTENANCE**

Improperly maintained equipment can result in poor work, but most importantly it can cause physical injury or death through fires or electrical shock. Therefore:

- a. Always have qualified personnel perform the installation, troubleshooting, and maintenance work. Do not perform any electrical work unless you are fully qualified.
- b. Before performing any maintenance work inside a power supply, disconnect the power supply from the electrical power source.
- c. Maintain cables, grounding wire, connections, power cord, and power supply in safe working order. Do not operate any equipment in questionable condition.
- d. Do not abuse any equipment or accessories. Keep equipment away from heat sources such as furnaces, wet conditions such as water puddles, oil or grease, corrosive atmospheres, and inclement weather.
- e. Keep all safety devices, guards, panels, and covers in position and in good repair.
- f. Use equipment for its intended purpose. Do not modify it in any manner.

## **1 - 8. ADDITIONAL SAFETY INFORMATION**

For more information on safe practices for setting up and operating electric welding and cutting equipment and on good working habits, ask your welding equipment supplier. The following publications, which are available from the American Welding Society, 550 N.W. LeJuene Rd., Miami, FL 33126, are recommended to you:

- a. "Safety in Welding and Cutting" - AWS Z49.1 (ANSI)
- b. "Recommended Safe Practices for Gas-Shielded Arc Welding" - AWS A6.1
- c. "Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances" - AWS F4.1
- d. NFPA Standard 51B, "Fire Prevention in Use of Cutting and Welding Processes," available from the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.
- e. NFPA Standard 70, "National Electrical Code," available from the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.
- f. ANSI Standard Z87.1, "Safe Practice for Occupation and Educational Eye and Face Protection," available from the American National Standards Institute, 1430 Broadway, New York, NY 10018.
- g. OSHA Standard 29 CFR, Part 1910, Subpart Q, "Welding, Cutting, and Brazing," available from the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.
- h. CSA Standard W117.2, "Code for Safety in Welding and Cutting," available from the Canadian Standards Association, 178 Rexdale Blvd., Rexdale, Ontario, Canada M9W 1R3.
- i. See also the Standards Booklet Index in the welding power source Owner's Manual.

## SECTION 2 - INTRODUCTION

Model	Ampere Rating at 100% Duty Cycle DCEN; ACHF	Tungsten Size Capacity	Cable Length	Torch Body	Cooling Method	Weight	
						Net	Ship
MTTF-1512	150 Amperes With Argon*	.020 thru 1/8 in. (0.5 thru 3.2 mm)	12.5 ft. (3.8 m)	Length: 8.0 in. (203.0 mm) Handle Diameter: 0.75 in. (19.0 mm)	Air	2.5 lbs. (1.1 kg)	3 lbs. (1.4 kg)
MTTF-1525			25 ft. (7.6 m)	Weight: 5.6 oz. (160 g)		4.5 lbs. (2.0 kg)	5 lbs. (2.3 kg)
MTTF-1512V			12.5 ft. (3.8 m)	Length: 8.75 in. (222.0 mm) Handle Diameter: 0.88 in. (22.5 mm)		2.5 lbs. (1.1 kg)	3 lbs. (1.4 kg)
MTTF-1525V			25 ft. (7.6 m)	Weight: 7.5 oz. (210 g)		5 lbs. (2.3 kg)	5 lbs. (2.3 kg)

\*Rated With Gas Lens Collet Body

Figure 2 - 1. Specifications

**2 - 1. DUTY CYCLE** - The duty cycle of a welding torch is the percentage of a ten minute period that a torch can be operated at a given load. This torch is rated at 100% duty cycle using argon shielding gas. This means that the torch can be operated at rated load conditions continuously.

**CAUTION: EXCEEDING THE RATED AMPERAGE** and duty cycle can result in damage to the torch.

- Do not exceed rated amperage and duty cycle stated in Figure 2-1.

### 2 - 2. GENERAL INFORMATION AND SAFETY

#### A. General

Information presented in this manual and on various labels, tags, and plates on the unit pertains to equipment design, installation, operation, maintenance, and troubleshooting which should be read, understood, and followed for the safe and effective use of this equipment.

#### B. Safety

The installation, operation, maintenance, and troubleshooting of arc welding equipment requires practices and procedures which ensure personal safety and the safety of others. Therefore, this equipment is to be installed, operated, and maintained only by qualified persons in accordance with this manual and all applicable codes such as, but not limited to, those listed at the end of Section 1 - Safety Rules.

Safety instructions specifically pertaining to this unit appear throughout this manual highlighted by the signal words **WARNING** and **CAUTION** which identify different levels of hazard.

**WARNING** statements include installation, operation, and maintenance procedures or practices which if not carefully followed could result in serious personal injury or loss of life.

**CAUTION** statements include installation, operation, and maintenance procedures or practices which if not carefully followed could result in minor personal injury or damage to this equipment.

A third signal word, **IMPORTANT**, highlights instructions which need special emphasis to obtain the most efficient operation of this equipment.

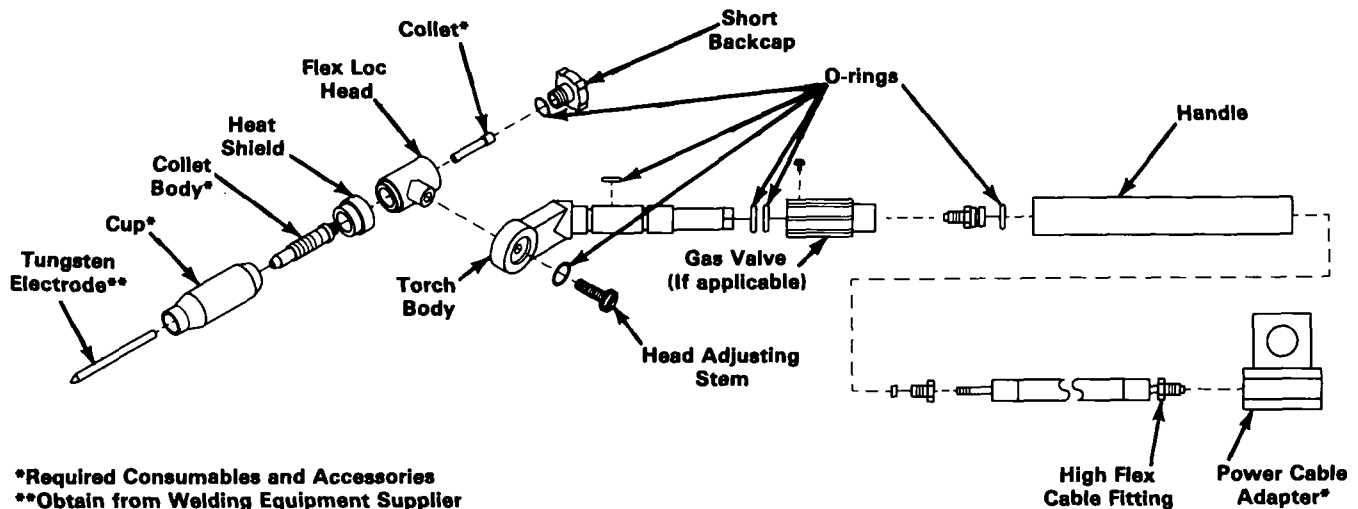
**2 - 3. RECEIVING HANDLING** - Before installing this equipment, clean all packing material from around the unit, and carefully inspect for any damage that may have occurred during shipment. Any claims for loss or damage that may have occurred in transit must be filed by the purchaser with the carrier. A copy of the bill of lading will be furnished by the manufacturer on request if occasion to file claim arises.

When requesting Information concerning this equipment, it is essential that Model Description and Style Numbers of the equipment be supplied. The style number is located on a label under the torch handle.

**2 - 4. DESCRIPTION** - This torch is specifically for use with the Gas Tungsten Arc Welding (GTAW) process. The alphanumeric model designation refers to the following:

M - Miller  
T - TIG/GTAW  
T - Torch  
F - Flex Loc Head  
15 - Ampere Rating: 150 Amperes  
12 - 12.5 ft. (3.8 m) Cable  
25 - 25 ft. (7.6 m) Cable  
V - Gas Valve

## SECTION 3 - INSTALLATION



\*Required Consumables and Accessories  
\*\*Obtain from Welding Equipment Supplier

Figure 3 - 1. Torch Components

TB-120 867

### **WARNING :** ELECTRIC SHOCK can kill.

- Do not touch live electrical parts.
- Shut down welding power source and disconnect input power employing "lockout/tagging procedures" before installing torch.

Lockout/tagging procedures consist of padlocking line disconnect switch in open position, removing fuses from fuse box, or shutting off and red-tagging circuit breaker or other disconnecting device.

### 3 - 1. TORCH BODY (Figure 3-1)

#### A. Torch Body Assembly

The torch body is shipped requiring consumables and accessories indicated in Figure 3-1: cup, collet body, collet, power cable adapter and tungsten electrode. Assemble torch body as follows:

1. Install collet body into torch head making sure heat shield is in place.
2. Install cup onto collet body.
3. Remove backcap and install standard collet, slotted end first, through back of torch body into collet body. If using reverse collet, install collet with slotted end toward backcap.
4. Loosely install backcap and O-ring (supplied on backcap) onto torch head.

5. Install properly prepared tungsten electrode (see Section 5-4) through front of collet body to position electrode tip outside cup rim. Securely tighten backcap.

To readjust electrode, loosen backcap.

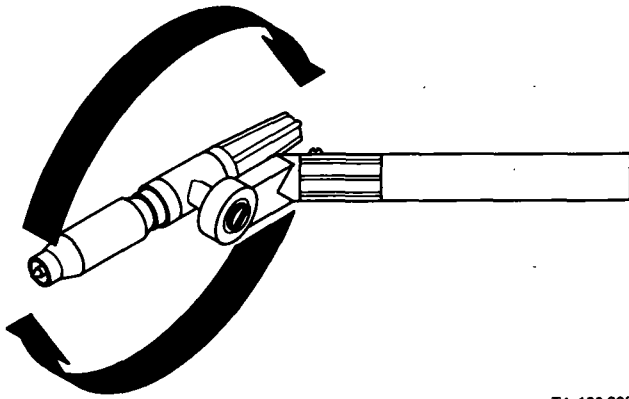
**IMPORTANT :** As a general rule, electrode extension should equal electrode diameter; but exact electrode extension may vary according to application.

#### B. Flex Loc Head Adjustment (Figures 3-1, 3-2, and 3-3)

The flex loc head can be locked in any position within its 360 degree rotation (Figure 3-1).

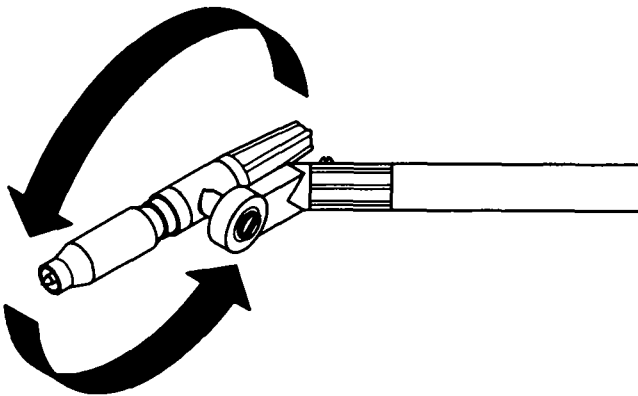
Adjust the flex loc head as follows:

1. Hold head adjusting stem in place, and rotate head clockwise one full turn.
2. Push head into torch body until adjusting stem turns freely.
3. Rotate head and adjusting stem simultaneously in same direction until desired angle is attained.
4. Hold adjusting stem in place, and rotate head counterclockwise until secure.



TA-120 998

Figure 3 - 2. Clockwise Head Rotation



TA-120 998

Figure 3 - 3. Counterclockwise Head Rotation

### 3 - 2. GAS HOSE CONNECTIONS AND GAS VALVE (If applicable)

**IMPORTANT:** If power source is not equipped with a gas valve, a torch gas valve is required (Figure 3-4).

#### A. Gas Hose and Connection

The high flex cable contains the power cable within the gas hose. The high flex cable has a 3/8-24 male right-hand fitting (Figure 3-1).

To install high flex cable, connect high flex cable fitting to power cable adapter.

If torch includes a gas valve, connect a suitable length of gas hose (extra hose not supplied) from power cable adapter to regulator/flowmeter (Figure 3-4).

If torch is without gas valve, connect a suitable length of gas hose (not supplied) from power cable adapter to gas valve outlet. Connect extra gas hose (not supplied) from gas valve inlet to regulator/flowmeter (Figure 3-5).

#### B. Torch Gas Valve Operation (If applicable)

The gas valve allows gas flow control at the torch. A one-quarter turn clockwise opens the gas valve, and a one-quarter turn counterclockwise closes the valve.

The gas valve allows control of gas postflow time, or the length of time gas flows after the arc is extinguished. Insufficient gas postflow results in an oxidized (black) electrode surface. If an oxidized electrode were used, the black surface would contaminate the weld and cause poor arc direction.

**IMPORTANT:** As a general rule, allow 10 seconds gas postflow time per 100 amperes of weld current before closing valve.

### 3 - 3. POWER CABLE CONNECTION (Figures 3-1, 3-4 and 3-5)

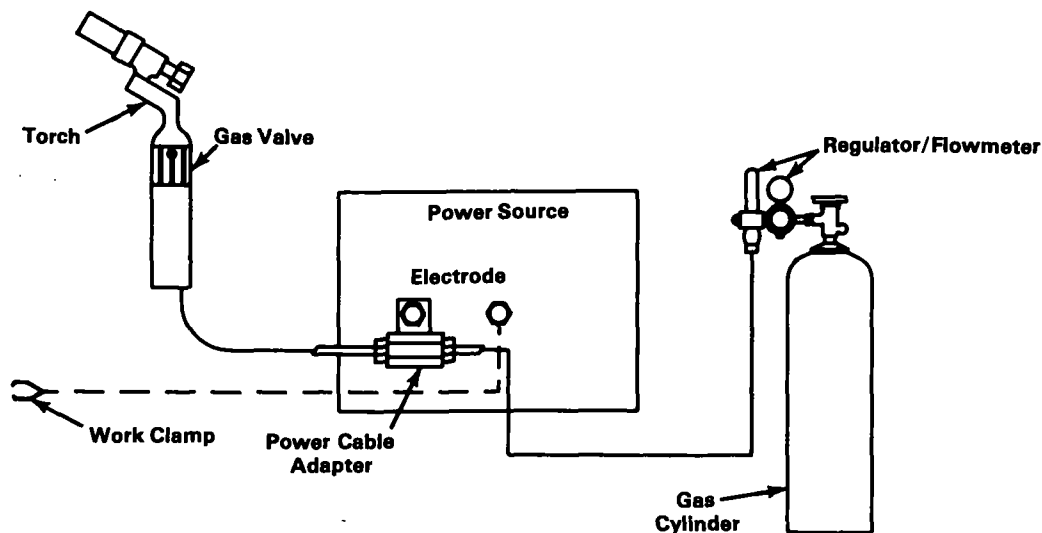
**WARNING:** ELECTRIC SHOCK can kill.

- Do not touch live electrical parts.
- Shut down welding power source and disconnect input power employing "lockout/tagging procedures" before installing torch.

Lockout/tagging procedures consist of padlocking line disconnect switch in open position, removing fuses from fuse box, or shutting off and red-tagging circuit breaker or other disconnecting device.

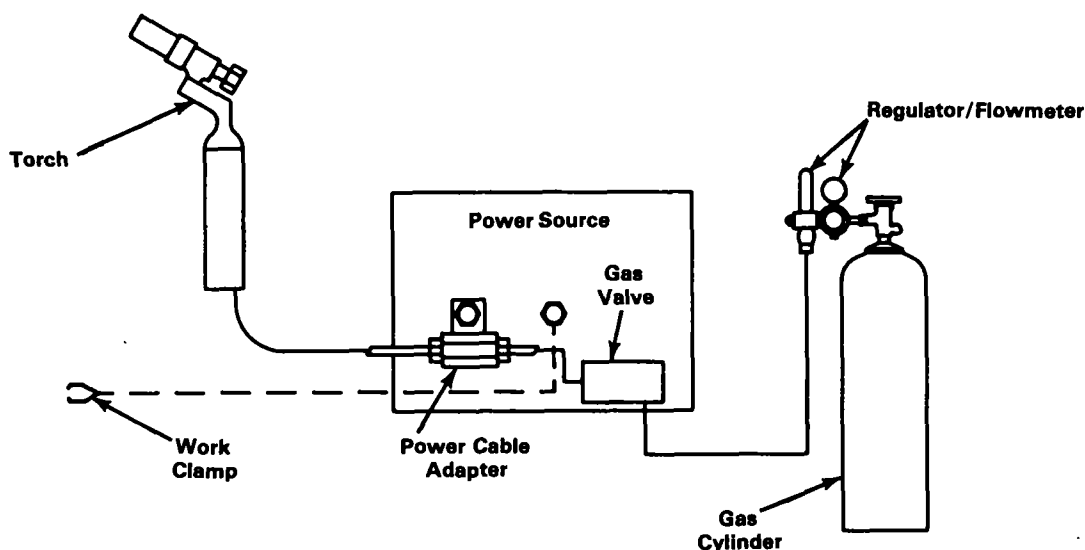
The high flex cable assembly contains the power cable within the gas hose. The high flex cable has a 3/8-24 male right-hand fitting (Figure 3-1).

To install high flex cable, connect high flex cable fitting to power cable adapter (see Section 3-2A). Connect power cable adapter to weld output terminal (Figures 3-4 and 3-5).



TA-120 871

Figure 3 - 4. Torch Connection Diagram For Models With Gas Valve



TA-120 871

Figure 3 - 5. GTAW Torch Connection Diagram For Models Without Gas Valve

## SECTION 4 - SEQUENCE OF OPERATION

### **WARNING:** ELECTRIC SHOCK can kill.

- Do not touch live electrical parts.
- Keep all covers and handle in place while operating.

**ARC RAYS, SPARKS, AND HOT SURFACES** can burn eyes and skin; **NOISE** can damage hearing.

- Wear correct eye, ear, and body protection.

**FUMES AND GASES** can seriously harm your health.

- Ventilate to keep from breathing fumes and gases.
- If ventilation is inadequate, use approved breathing apparatus.

**HOT METAL, SPATTER, AND SLAG** can cause fire and burns.

- Watch for fire.
- Have a fire extinguisher nearby, and know how to use.
- Allow work and equipment to cool before handling.

**MAGNETIC FIELDS FROM HIGH CURRENTS** can affect pacemaker operation.

- Wearers should consult with their doctor before going near arc welding, gouging, or spot welding operations.

See Section 1 - Safety Rules for additional safety information.

### 4 - 1. GAS TUNGSTEN ARC WELDING (GTAW)

1. Install and connect torch according to Section 3.
2. Make sure backup and all gas connections are securely tightened.
3. With regulator/flowmeter valve closed, open gas cylinder valve.
4. Set power source for desired welding amperage.



5. Wear dry insulating clothing and gloves and welding helmet with proper filter lens according to ANSI Z49.1.

6. Energize welding power source.

7. Set gas flow to desired level (requires open gas valve).

**IMPORTANT:** *Purge gas hose to clear hose of air, moisture, or any other contaminants. Allow gas to flow 2 to 3 minutes on new torch; 5 to 6 seconds thereafter.*

8. Begin welding.

## 4 - 2. SHUTTING DOWN

1. Stop welding.

**IMPORTANT:** *As a general rule, allow 10 seconds of gas postflow time per 100 amperes of weld current before closing valve.*

2. Turn off welding power source.

3. Turn off the shielding gas.

**WARNING: HIGH CONCENTRATION OF SHIELDING GAS** can harm health or kill.

- *Shut off gas supply when not in use.*

## SECTION 5 - MAINTENANCE

**5 - 1. INSPECTION AND UPKEEP** - Usage and shop conditions will determine frequency and type of maintenance required. Perform inspections once a week.

**WARNING: ELECTRIC SHOCK** can kill; **HOT SURFACES** can cause severe burns.

- *Do not touch live electrical parts.*
- *Shut down welding power source before working on torch.*
- *Disconnect torch from welding power source before inspecting, maintaining, or servicing.*
- *Allow a cooling period before servicing.*

1. Inspect torch for broken areas, cracks and loose parts; tighten, repair and replace as required.

2. Remove grease and dirt from components, and moisture from electrical parts and cables.

### 5 - 2. TORCH BODY MAINTENANCE (Figure 3-1)

**WARNING: ELECTRIC SHOCK** can kill; **HOT SURFACES** can cause severe burns.

- *Do not touch live electrical parts.*
- *Shut down welding power source before working on torch.*
- *Disconnect torch from welding power source before inspecting, maintaining, or servicing.*
- *Allow a cooling period before servicing.*

Once a week inspect condition of torch body components.

Replace cup, heat shield, backcap, and O-rings if cracked. Maintain tight fit of torch components to ensure good weld quality.

### 5 - 3. INSPECTING HOSES, CONNECTIONS AND CABLES

**WARNING: ELECTRIC SHOCK** can kill.

- *Do not touch live electrical parts.*
- *Shut down welding power source and disconnect input power employing "lockout/tagging procedures" before inspecting, maintaining, or servicing.*

Lockout/tagging procedures consist of padlocking line disconnect switch in open position, removing fuses from fuse box, or shutting off and red-tagging circuit breaker or other disconnecting device.

Once a week inspect hoses and connections.

#### A. Gas Hose

Gas leaks may result in poor weld quality. Inspect hoses for breaks. Keep connections clean and tight.

#### B. Power Cable

Inspect cables for breaks in insulation, and ensure that all connections are clean and tight. Repair or replace cables if insulation breaks are present. Clean and tighten connections at each inspection.

### 5 - 4. PREPARING TUNGSTEN ELECTRODES (Figure 5-1)

**CAUTION: HOT FLYING METAL PARTICLES** can injure personnel, start fires, and damage equipment; **TUNGSTEN CONTAMINATION** can lower weld quality.

- *Shape tungsten electrode only with properly guarded grinder in a safe location wearing proper face, hand, and body protection.*
- *Do not use same wheel for any other job or the tungsten will become contaminated.*

Tungsten electrode shaping should be done on a fine grit, hard abrasive wheel. Since tungsten is harder than most grinding wheels, causing the tungsten to be chipped away rather than cut away, the grinding marks should run lengthwise with the electrode.

For additional information, see your distributor or request a handbook from factory on the Gas Tungsten Arc Welding (GTAW) process.

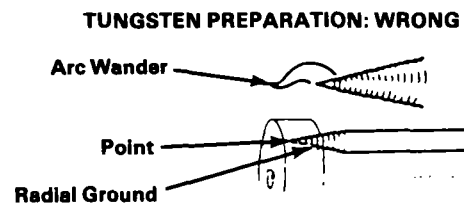
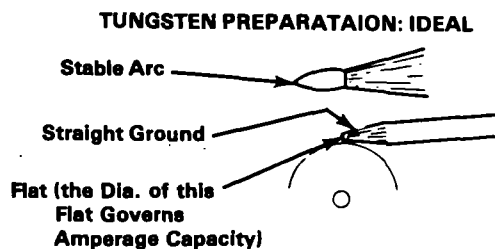


Figure 5 - 1. Tungsten Preparation

TA-120 630

Table 5 - 1. Tungsten Size Chart

Electrode Diameter	Amperage Range - Polarity - Gas Type		
Pure Tungsten (Green Band)	DC-Argon Electrode Negative/ Straight Polarity	DC-Argon Electrode Positive/ Reverse Polarity	AC-Argon Using High Frequency
.020"	5-20	*	5-20
.040"	15-80	*	10-60
1/16"	70-150	10-20	50-100
3/32"	125-225	15-30	100-160
1/8"	225-360	25-40	150-210
2% Thorium Alloyed Tungsten (Red Band)			
.020"	15-40	*	15-35
.040"	25-85	*	20-80
1/16"	50-160	10-20	50-150
3/32"	135-235	15-30	130-250
1/8"	250-400	25-40	225-360
Zirconium Alloyed Tungsten (Brown Band)			
.020"	*	*	15-35
.040"	*	*	20-80
1/16"	*	*	50-150
3/32"	*	*	130-250
1/8"	*	*	225-360

\*NOT RECOMMENDED

The figures are intended as a guide and are a composite of recommendations from American Welding Society (AWS) and electrode manufacturers.

Item No.	Miller Stock No.	Miller Model No.	Description	Quantity
----------	------------------	------------------	-------------	----------

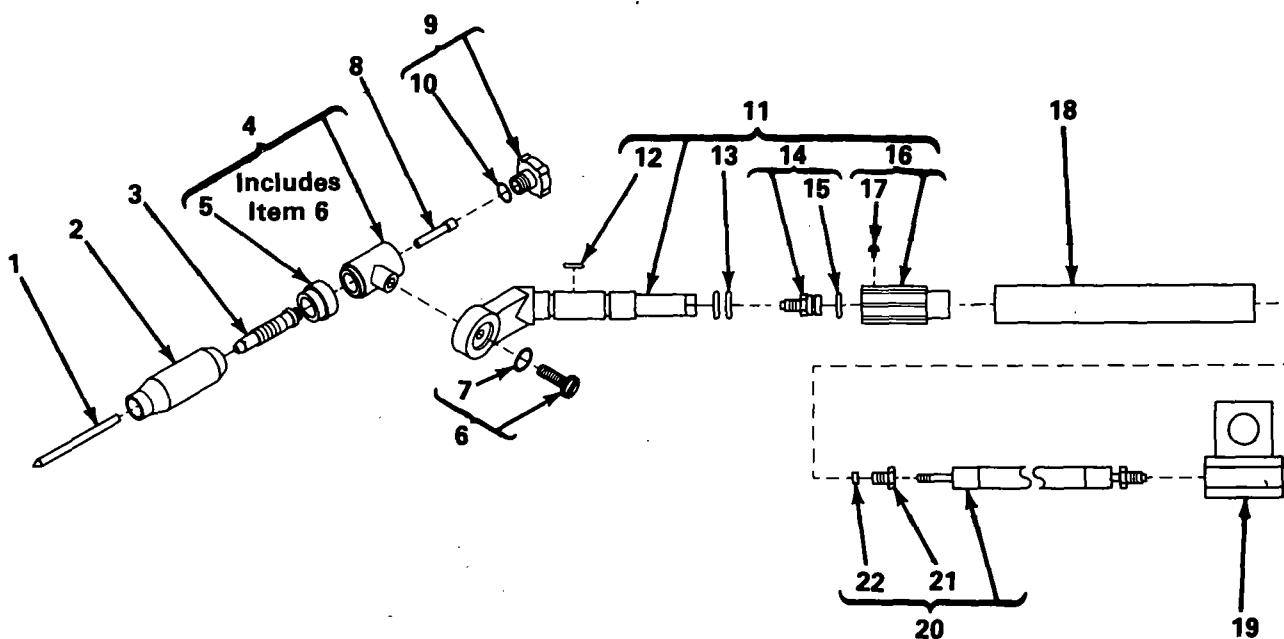
**Figure A Complete Torch Assembly**

1			TUNGSTEN, electrode (consult your welding supply distributor)	
2			CUP (see Figure B)	
3			COLLET BODY (see Figure B)	
4	118 526	FL3L	3 SERIES HEAD (consisting of)	1
5	116 256	300HS	. HEAT SHIELD, std	1
5	†119 914	3GHS	HEAT SHIELD, small dia gas lens	1
5	†119 915	3GHSLD	HEAT SHIELD, large dia gas lens	1
6	116 203	01-0009	HEAD ADJUSTMENT STEM (consisting of)	1
7	116 260	300R	. O-RING	1
8			COLLET (see Figure B)	
9	116 259	300S	BACKCAP, short (consisting of)	1
9	†116 258	300M	BACKCAP, medium (consisting of)	1
9	†116 257	300L	BACKCAP, long (consisting of)	1

Item No.	Miller Stock No.	Miller Model No.	Description	Quantity
----------	------------------	------------------	-------------	----------

**Figure A Complete Torch Assembly (Cont'd)**

10	116 260	300R	. O-RING	1
11	116 208		FLEX LOC TORCH BODY, w/valve (consisting of)	1
12	116 219	01-0012	. O-RING	1
13	116 217	01-0002	. O-RING	2
14	116 220	01-0013	. HANDLE ADAPTER, models w/valve (consisting of)	1
15	116 217	01-0002	. O-RING	1
16	116 216	FLHV	. VALVED HANDLE, models w/valve (consisting of)	1
17	116 218	01-0007	. SCREW, non-conductive	1
11	116 207		FLEX LOC TORCH BODY (consisting of)	1
13	116 217	01-0002	. O-RING	2
18	118 510		HANDLE	1
19	†116 276	15PCA	POWER CABLE ADAPTER	1
20	116 271	1512PCHF	HI-FLEX POWER CABLE, 12-1/2 ft (consisting of)	1
20	116 272	1525PCHF	HI-FLEX POWER CABLE, 25 ft (consisting of)	1
21	120 721		. RH NUT	2
22	120 720		. RING NUT	2



**Figure A - Complete Torch Assembly**

†Optional Parts

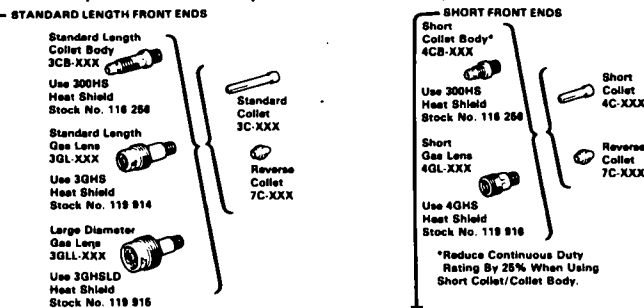
BE SURE TO PROVIDE MODEL AND STYLE NUMBER WHEN ORDERING REPLACEMENT PARTS.

TB-120 867

# CONSUMABLE PARTS SELECTOR

(Note: Collet, Collet Body And Gas Cup Required To Complete Torch.) Torches With High Flex Composite Cable Also Require A Power Cable Adapter.

Tungsten Diameter	in. (mm)	.020" (0.5)	.040" (1.0)	1/16" (1.6)	3/32" (2.4)	1/8" (3.2)
Amperage Range	ACHF DCSP	5-20 5-20	10-80 15-80	50-150 70-150	100-235 150-250	150-325 220-350
Collet (Standard)	Model No. Stock No.	3C20 116 367	3C40 116 368	3C116 116 369	3C332 116 370	3C418 116 371
Collet (Reverse)	Model No. Stock No.	7C20 116 379	7C40 116 380	7C116 116 381	7C332 116 382	7C418 116 383
Collet Body (Std. Lgth.)	Model No. Stock No.	3CB20 116 361	3CB40 116 362	3CB116 116 363	3CB332 116 364	3CB418 116 365
Cup, Ceramic 1-27/32" Long	Stock/Model No.	116 347 (3C3)				3/16"
		116 348 (3C4)				1/4"
		116 349 (3C5)				5/16"
		116 350 (3C6)				3/8"
		116 351 (3C7)				7/16"
		116 352 (3C8)				1/2"
Cup, Ceramic 3-7/32" Long		116 353 (3C10)				5/8"
		116 354 (3C12)				3/4"
		116 343 (3C4L)				1/4"
		116 344 (3C5L)				5/16"
		116 345 (3C6L)				3/8"
		116 346 (3C7L)				7/16"
Cup, Alumina 1-27/32" Long		116 330 (3A4)				1/4"
		116 331 (3A5)				5/16"
		116 332 (3A6)				3/8"
		116 333 (3A7)				7/16"
		116 334 (3A8)				1/2"
		116 335 (3A10)				5/8"
Gas Lens Collet Body Std. Lgth.		116 336 (3A12)				3/4"
	Model No. Stock No.	3GL20 119 926	3GL40 119 927	3GL116 119 928	3GL332 119 929	3GL418 119 930
	Stock/Model No.	119 917 (3CG4)				1/4"
		119 918 (3CG5)				5/16"
		119 919 (3CG6)				3/8"
		119 920 (3CG7)				7/16"
Cup, Ceramic - Gas Lens 1-5/8" Long		119 921 (3CG8)				1/2"
		119 922 (3CG11)				11/16"
		119 923 (3CG12)				3/4"
		119 924 (3CG14)				7/8"
		119 925 (3CG16)				1"
		119 932 (3AG4)				1/4"
Cup, Alumina - Gas Lens 1-5/8" Long		119 933 (3AG5)				5/16"
		119 934 (3AG6)				3/8"
		119 935 (3AG7)				7/16"
		119 936 (3AG8)				1/2"
		119 937 (3AG11)				11/16"
	Model No. Stock No.	3GL20 119 905	3GL40 119 906	3GL116 119 907	3GL332 119 908	3GL418 119 909
Gas Lens Collet Body Lg. Dia.	Stock/Model No.	119 911 (3AG8LD)				1/2"
		119 912 (3AG10LD)				5/8"
		119 913 (3AG12LD)				3/4"
		119 914 (3AG14LD)				7/8"
		119 915 (3AG16LD)				1"
		119 916 (3AG18LD)				1 1/8"



Tungsten Diameter	in. (mm)	.020" (0.5)	.040" (1.0)	1/16" (1.6)	3/32" (2.4)	1/8" (3.2)
Amperage Range	ACHF DCSP	5-20 5-20	10-80 15-80	50-150 70-150	100-235 150-250	150-325 220-350
Collet (Short)	Model No. Stock No.	4C20 116 373	4C40 116 374	4C116 116 375	4C332 116 376	4C418 116 377
Collet (Reverse)	Model No. Stock No.	7C20 116 379	7C40 116 380	7C116 116 381	7C332 116 382	7C418 116 383
Collet Body (Short)	Model No. Stock No.	4CB20 116 355	4CB40 116 356	4CB116 116 357	4CB332 116 358	4CB418 116 359

Cup, Ceramic 1-5/32" Long	Stock/Model No.	116 337 (2C4)				1/4"
		116 338 (2C5)				5/16"
		116 339 (2C6)				3/8"
		116 340 (2C7)				7/16"
		*116 341 (2C8)				1/2"
		*116 342 (2C10)				5/8"
Cup, Ceramic - Long 1-7/8"		116 326 (2C3L)				3/16"
		116 327 (2C4L)				1/4"
		116 328 (2C5L)				5/16"
		116 329 (2C6L)				3/8"
Cup, Alumina 1-5/32" Long		116 310 (2A4)				1/4"
		116 311 (2A5)				5/16"
		116 312 (2A6)				3/8"
		116 313 (2A7)				7/16"
		116 314 (2A8)				1/2"
		116 315 (2A10)				5/8"
Gas Lens Collet Body - Short	Model No. Stock No.	4GL20 119 905	4GL40 119 906	4GL116 119 907	4GL332 119 908	4GL418 119 909
	Stock/Model No.	119 893 (2AG4)				1/4"
		119 894 (2AG5)				5/16"
		119 895 (2AG6)				3/8"
		119 896 (2AG7)				7/16"
		119 897 (2AG8)				1/2"

SHADED AREAS INDICATE  
RECOMMENDED USAGE

Figure B - Consumable Parts And Cross Reference Chart

**CROSS REFERENCE TO  
COMPETITIVE MODEL**

MILLER STOCK NO.	MILLER MODEL NO.	COMPETITIVE NO.
116 367	3C20	10N21
116 368	3C40	10N22
116 369	3C116	10N23
116 370	3C332	10N24
116 371	3C418	10N25
116 379	7C20	N/A
116 380	7C40	N/A
116 381	7C116	N/A
116 382	7C332	N/A
116 383	7C418	N/A
116 361	3CB20	10N29
116 362	3CB40	10N30
116 363	3CB116	10N31
116 364	3CB332	10N32
116 365	3CB418	10N28
116 347	3C3	N/A
116 348	3C4	105Z43
116 349	3C5	105Z42
116 350	3C6	105Z44
116 351	3C7	105Z45
116 352	3C8	08N78
116 353	3C10	08N79
116 354	3C12	08N80
116 343	3C4L	12N03
116 344	3C5L	105Z60
116 345	3C6L	12N02
116 346	3C7L	105Z61
116 330	3A4	10N50
116 331	3A5	10N49
116 332	3A6	10N48
116 333	3A7	10N47
116 334	3A8	10N46
116 335	3A10	10N45
116 336	3A12	10N44
119 926	3GL20	45V29
119 927	3GL40	45V24
119 928	3GL116	45V25
119 929	3GL332	45V26
119 930	3GL418	45V27
119 917	3CG4	54N35
119 918	3CG5	54N34
119 919	3CG6	54N33
119 920	3CG7	54N32
119 921	3CG8	54N31
119 922	3CG11	54N36
119 923	3CG12	N/A
119 924	3CG14	N/A
119 925	3CG16	N/A
119 932	3AG4	54N18
119 933	3AG5	54N17

MILLER STOCK NO.	MILLER MODEL NO.	COMPETITIVE NO.
119 934	3AG6	54N16
119 935	3AG7	54N15
119 936	3AG8	54N14
119 937	3AG11	54N19
119 902	3GLL332	45V64
119 903	3GLL418	995795
119 911	3AG8LD	57N74
119 912	3AG10LD	53N88
119 913	3AG12LD	53N87
116 373	4C20	N/A
116 374	4C40	10N22S
116 375	4C116	10N23S
116 376	4C332	10N24S
116 377	4C418	10N25S
116 379	7C20	N/A
116 380	7C40	N/A
116 381	7C116	N/A
116 382	7C332	N/A
116 383	7C418	N/A
116 355	4CB20	N/A
116 356	4CB40	17CB20
116 357	4CB116	17CB20
116 358	4CB332	17CB20
116 359	4CB418	17CB20
116 337	2C4	13N14
116 338	2C5	13N15
116 339	2C6	13N16
116 340	2C7	13N17
116 341	2C8	13N18
116 342	2C10	13N19
116 326	2C3L	796F70
116 327	2C4L	796F71
116 328	2C5L	796F72
116 329	2C6L	796F73
116 310	2A4	13N08
116 311	2A5	13N09
116 312	2A6	13N10
116 313	2A7	13N11
116 314	2A8	13N12
116 315	2A10	13N13
119 905	4GL20	N/A
119 906	4GL40	N/A
119 907	4GL116	N/A
119 908	4GL332	N/A
119 909	4GL418	N/A
119 893	2AG4	53N58
119 894	2AG5	53N59
119 895	2AG6	53N60
119 896	2AG7	53N61







1

